

Work Order ID 111118

Thursday, January 09, 2014 11:29:00 AM

111118

Page 1

Item ID: PB67-43001-59

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Adjustable Attachment Arm

Stop *NS2*

Start Date: 1/8/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/24/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: mf

Date: 14-01-09

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

B67-43001-59

Rev C

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1- to make -105 take M6061T6 tube and fabricate to fit contour of cut

2- Weld -105 to -113 as per dwg and grind weld flush

3- weld 119, -117 and -115 to -113 as per dwg PB67-43001

4- pick two -271 and weld one on each side of tubing but only one need to

2 14-01-21 PD

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

QC 14-01-23

2*

Work Order ID 111118***111118***

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Stop ***NS2***

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Start Date: 1/8/2014 Start Qty: 1.00

1

2

Cust Item ID:

Required Date: 1/24/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120						2			
QC	Memo	0.00							
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130						2			
HandFinish	Memo	0.00							
Hand Finishing									
140	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00							
140						2			
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 8:40								
	OVEN TEMPERATURE: 320°								
	FINISH TIME: 9:10								

DAS
34
999

Work Order ID 111118

111118

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Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>MA-003</u>	0.00							
180									
Packaging	Memo	0.00				2	0		<u>19</u> 14-02-18
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

14-02-19

14-2-18

100

Picklist Print

Thursday, January 09, 2014 11:28:59 AM

Page 1

Work Order ID: 111118

Parent Item: PB67-43001-59

Parent Item Name: Adjustable Attachment Arm

Start Date: 1/8/2014

Required Date: 1/24/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-07-18 new issue DD verified by:ec
IPP Rev:B 08-11-21 Qty for BSP43 revised per W/O 43054 KJ Verified by: eC IPP RevC
10.09.29 per revC dwg EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-121 Square Sleeve		Manufactured	No			160	Each	4.0000	1	1		② 14-02-14 PD	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz2		4							
				⑩00009		4				2			
PB67-43001-267 Pad Attachment Assembly		Manufactured	No			160	Each	14.0000	1	1		② 14-02-14 PD	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz2		14							
				44976		1							
				⑨9962		6				2			
				99966		7							
30345T21 LANYARD		Purchased	No			160	Each	0.0000	2	2		④ 14-02-14 PD	
BSP43 RIVET		Purchased	No			160	Each	78.0000	4	4		⑧ 14-02-14 PD	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST282		78							
				⑩127380		78				8			
MS17984-C413 Quick Release Pin		Purchased	No			160	Each	47.0000	2	2		⑨ 14-02-14 PD	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST332		47							
				⑩126873		22				4			
				m127813		25							

Picklist Print

Thursday, January 09, 2014 11:28:59 AM

Page 2

Work Order ID: 111118

Parent Item: PB67-43001-59

Start Date: 1/8/2014

Required Date: 1/24/2014

Parent Item Name: Adjustable Attachment Arm

Start Qty: 1.00

Required Qty: 1.00

MS21042L3 Purchased No 160 Each 6,020.0000 2 2 ⑨ 14-02-14 PD
Nut

Location Loc Qty Loc Code

ST506 962

123900 962

ST509 5000

M127304 1000

M127410 3000

M127831 1000

ST510a 58

M126333 58

MS27039-1-22 Purchased No 160 Each 125.0000 2 2 ⑨ 14-02-14 PD
SCREW

Location Loc Qty Loc Code

ST306 125

112940 100

18057 25

NAS1149D0332J Purchased No 160 Each 2,010.0000 4 4 ⑧ 14-02-14 PD
Washer

Location Loc Qty Loc Code

ST293 610

m127431 610

ST294 10

m125807 10

ST510a 1390

m127374 390

m127389 1000

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Shop Packet Print

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Picklist Print

Thursday, January 09, 2014 11:28:59 AM

Page 3

Work Order ID: 111118

Parent Item: PB67-43001-59

Start Date: 1/8/2014

Required Date: 1/24/2014

Parent Item Name: Adjustable Attachment Arm

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN416J

Purchased

No

160

Each

1,303.0000

4

4

Washer

③ 14-02-14 PD

Location

Loc Qty

Loc Code

GA

600

124983

600

ST293

703

124968

703

PB67-43001-105

Manufactured

No

100

Each

4.0000

1

1

Plug

② 14-01-20 PD

Location

Loc Qty

Loc Code

Mezz2

4

106424

4

PB67-43001-113

Manufactured

No

100

Each

2.0000

1

1

Square Tube

② 14-01-20 PD

Location

Loc Qty

Loc Code

Mezz2

2

100013

2

PB67-43001-115

Manufactured

No

100

Each

4.0000

1

1

Tube End Plate

② 14-01-20 PD

Location

Loc Qty

Loc Code

Mezz2

4

100012

3

24807

1

PB67-43001-117

Manufactured

No

100

Each

3.0000

1

1

Hook Plate

② 14-01-20 PD

Location

Loc Qty

Loc Code

Mezz2

3

100011

3

PB67-43001-119

Manufactured

No

100

Each

4.0000

1

1

End Cap Clevis

② 14-01-20 PD

Location

Loc Qty

Loc Code

Mezz2

4

100010

4

Thursday, January 09, 2014 11:28:59 AM

Shop Packet Print

Page 3

Picklist Print

Thursday, January 09, 2014 11:28:59 AM

Page 4

Work Order ID: 111118

Parent Item: PB67-43001-59

Start Date: 1/8/2014

Required Date: 1/24/2014

Parent Item Name: Adjustable Attachment Arm

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-271

Manufactured No

100

Each

15.0000

1

1

Doubler

Location

Loc Qty

Loc Code

Mezz2

15

44975

3

99965

12

PB67-43001-275

Manufactured No

160

Each

23.0000

1

1

Doubler

Location

Loc Qty

Loc Code

Mezz2

23

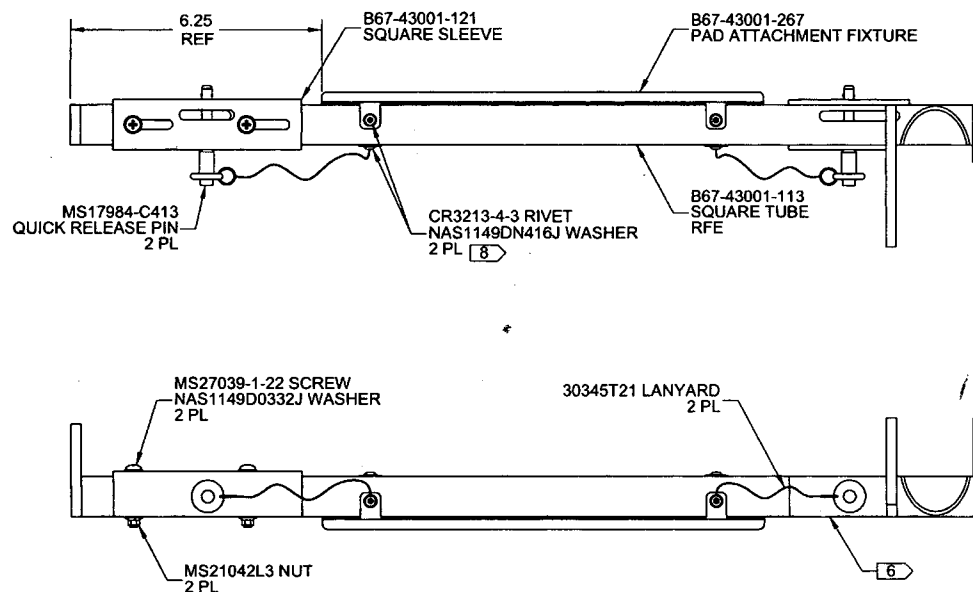
106423

23

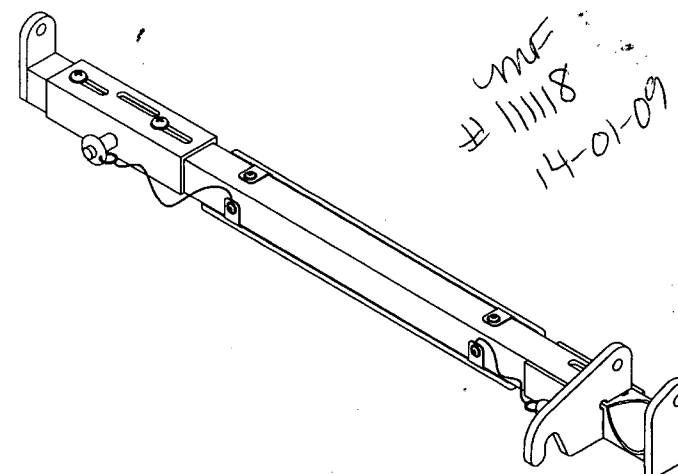
14-01-20 PD

14-01-20 PD

ITEM	QTY -59	P/N	DESCRIPTION
1	X	B67-43001-59	ADJUSTABLE ATTACHMENT ARM
3	1	B67-43001-121	SQUARE SLEEVE
4	1	B67-43001-267	PAD ATTACHMENT FIXTURE
6	2	30345T21	LANYARD
7	4	CR3213-4-3	RIVET (OR BSP43-4-3)
8	2	MS17984-C413	QUICK RELEASE PIN
9	2	MS21042L3	NUT
10	2	MS27039-1-22	SCREW
11	4	NAS1149D0332J	WASHER
12	4	NAS1149DN416J	WASHER



B67-43001-59 ADJUSTABLE ATTACHMENT ARM



RELEASED
2010-09-16
AWO

- NOTES:**
- 1) MATERIAL: NONE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-59" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 2.21 lbs
 - 8) FOLD -267 TABS OVER AND TRANSFER DRILL Ø0.130 FROM -267 TO -113 PRIOR TO INSTALL CR3213-4-3 RIVETS.

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 14 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	09.06.15
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	B67-43001-59	SHEET 1 OF 2
APPROVED	AS	TITLE	SCALE
DE APPR.	N/A	ADJUSTABLE ATTACHMENT ARM	NTS
DATE	09.06.15	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

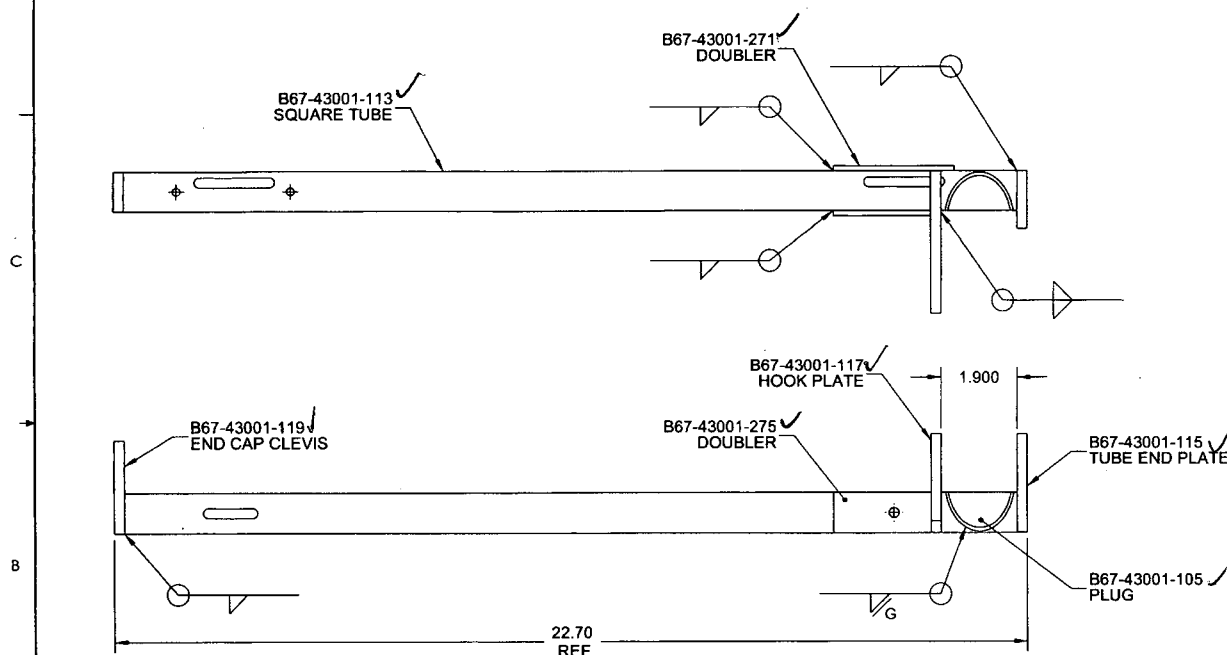
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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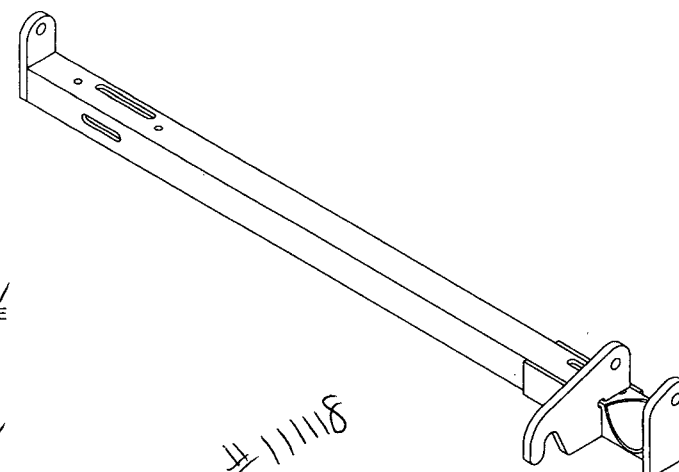
ITEM	QTY -59	P/N	DESCRIPTION
1	X	B67-43001-59W	ADJUSTABLE ATTACHMENT ARM WELDMENT
3	1	B67-43001-105	PLUG
4	1	B67-43001-113	SQUARE TUBE
5	1	B67-43001-115	TUBE END PLATE
6	1	B67-43001-117	HOOK PLATE
7	1	B67-43001-119	END CAP CLEVIS
8	1	B67-43001-271	DOUBLER
9	1	B67-43001-275	DOUBLER



B67-43001-59W ADJUSTABLE ATTACHMENT ARM
(WELDING DETAIL)

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.26 lbs
- 8) WELDING: PER QSI 004
- 9) MASK ALL HOLES AND OPENINGS PRIOR TO POWDER COAT



RELEASED
2010-08-16

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	B67-43001-59	SHEET 2 OF 2
APPROVED	AS	TITLE	SCALE
DE APPR.	N/A	ADJUSTABLE ATTACHMENT ARM	NTS
DATE	09.06.15	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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